

Work Order ID 57408 - 2

April 6, 2010 2:55:46 PM

Page 1

Item ID: D3262-043

Revision ID:

Item Name: Canister Assembly

Start Date: 4/06/10

Required Date: 4/12/10

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

D

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch 1113207 0.00

Large Fab

Memo

0.00

Weld canister assembly as per Dwg D3262 using DT8739 to align fittings

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Pressure test as per Dwg D3262



Accept



Setup Start



Stop



Cust Item ID:

Customer:



(x4)

BE 10/04/08

BE 10/04/14 PHO ->

(2) PD 10.04.15

(x2)

8/10/15

(3)

Handwritten signature

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3262-043 PAR #: _____ Fault Category: Skirt tubes NCR: Yes No DQA: _____ Date: 10/04/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/04/19

NCR: <u>57408-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/13</u>	<u>#100</u>	<u>Qty +1 cap D3262-5 cap</u> <u>the 3/4-16 unf 3B hole seized</u> <u>the plug in the hole unable to</u> <u>remove</u>	<u>[Signature]</u>	<u>-Scrap D3262-5 B 57408</u> <u>Qty +1</u>	<u>BE</u> <u>10/04/14</u>	<u>[Signature]</u> <u>10/04/14</u>	<u>[Signature]</u>	<u>[Signature]</u>
		<u>R.C. Process</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Work Order ID 57408

April 6, 2010 2:55:47 PM



Page 2

Item ID: D3262-043

Accept

Revision ID:

Item Name: Canister Assembly

Start Date: 4/06/10 Start Qty: 5.00

Required Date: 4/12/10 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

②. BR 10-4-15

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

****Ensure to mask threads ****

START TIME:

3:30pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

4:00pm

=> M 10/04/15

②. Ø

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 10-4-16

②.

Work Order ID 57408

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Page 3

Item ID: D3262-043

Accept

Revision ID:

Item Name: Canister Assembly

Start Date: 4/06/10 Start Qty: 5.00

Required Date: 4/12/10 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 144

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

C. 10/4/16 (2)

10/04/19

PT 10 - H-14
(2)



Picklist Print

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Page 1

Work Order ID: 57408

Parent Item: D3262-043

Parent Item Name: Canister Assembly

Comments: IPP rev A 10.01.19 new issue EC verified by: DD

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3262-1

Manufactured

No

100

Each

2.0000

5.0000



Tube

Warehouse

Location

Main Warehouse

WA

53504

Loc Qty

Loc Code

B 57657

2

2

Each

0.0000

5.0000

D3262-5

Manufactured

No

100



Cap

(x4)

(6) (x4)

B 57407

B 57407

BE 10/04/13
BE 10/04/08

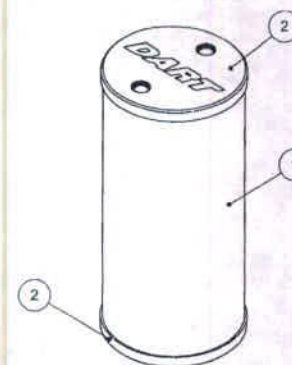
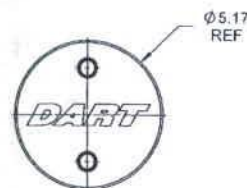
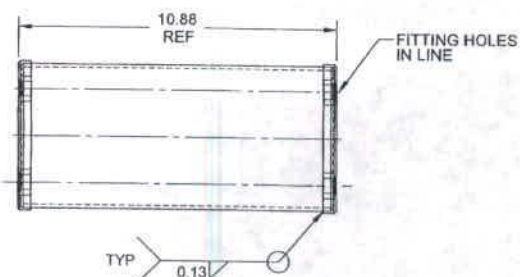
BE 10/04/13

BE 10/04/13

2 PC

2 PC

ITEM	QTY .041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



D3262-041 CANISTER ASSEMBLY

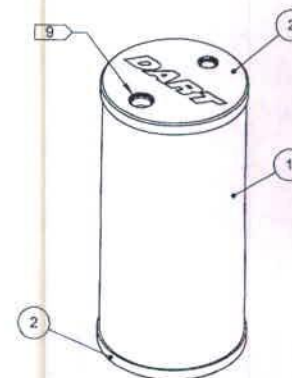
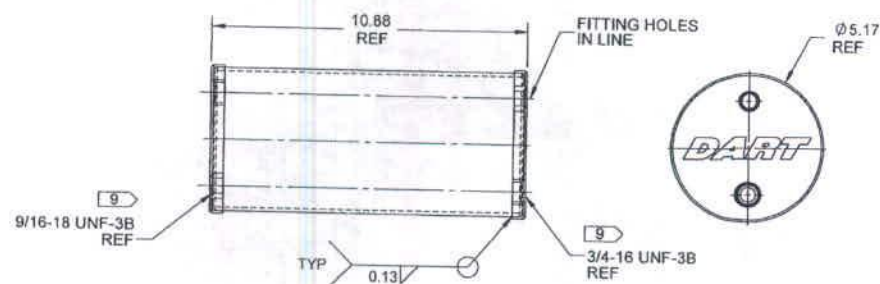
RELEASED
2010-01-14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.56 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D3262	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP



D3262-043 CANISTER ASSEMBLY

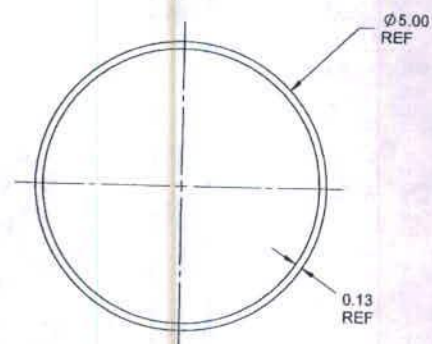
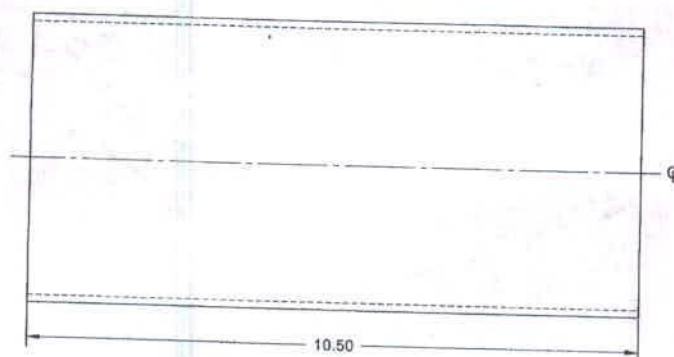
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.55 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

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CHECKED	RF	DRAWING NO. D3262	REV. D
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APPROVED	RF	SCALE	NTS
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57408



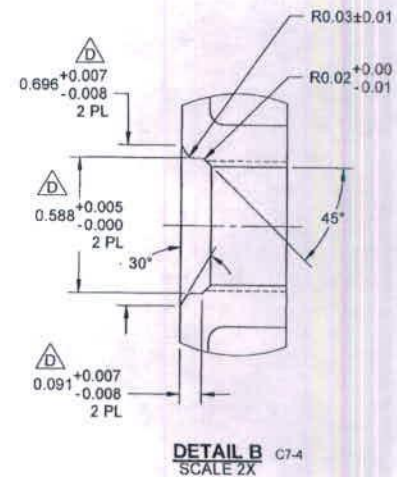
D3262-1 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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MP

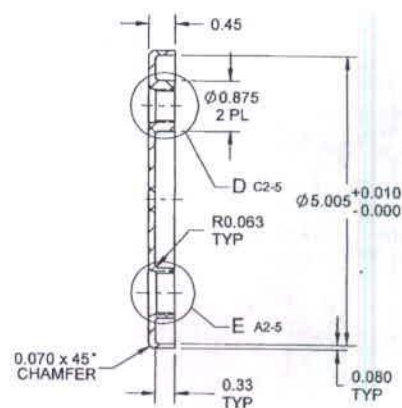
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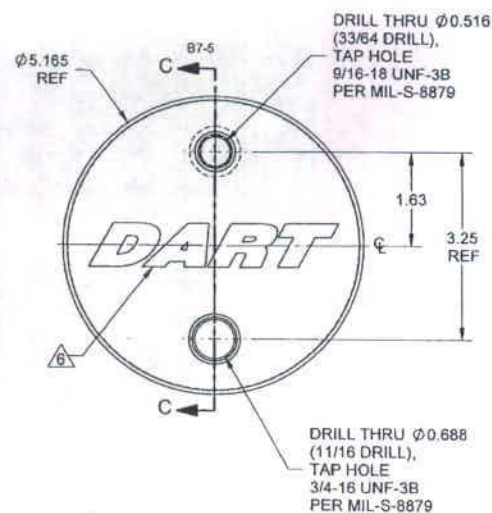
DETAIL B C7-4
SCALE 2X

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2010-01-14
MMP

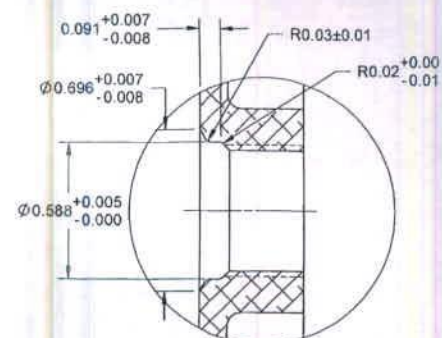
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|------------|----------|---|--------------|
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HAWKESBURY, ONTARIO, CANADA | REV. D |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO.
D3262 | SHEET 4 OF 6 |
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| DATE | 09.12.30 | | |



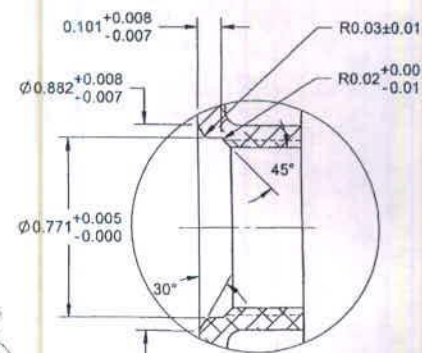
SECTION C-C D5-5



Δ D3262-5 CAP



DETAIL D C7-5
SCALE 2X



DETAIL E B7-5
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.29 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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CHECKED	RF	DRAWING NO. D3262	REV. D
MFG. APPR.	RF	TITLE FUEL PURGE CANISTER	SHEET 5 OF 5
APPROVED	RF	SCALE	NTS
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